

Work Order ID 74766 - 1

October 6, 2011 9:16:51 AM

\*74766\*

**U/R**

Page 1

Item ID: D2940-1

Revision ID: U/R

Item Name: Support

Accept

\*N900040100\*

Setup Start \*NS1\*

Stop \*NS2\*

Start Date: 10/06/11

Start Qty: 20.00

\*20\*

Cust Item ID:

Required Date: 11/15/11

Req'd Qty: 20.00

\*20\*

Customer:

Reference:

Approvals:

Process Plan: M.C.S

Date: 11/10/09

Tooling:

Date:

Run Start \*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D2940

C

100

\*100\*

HAAS 1

HAAS CNC vertical machine #1

HAAS CNC VERTICAL MACHINING #1

Memo

1-Machine as per Folio FA079  
2-Deburr

0.00

0.00

110

\*110\*

QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

0.00

120

\*120\*

QC

Quality Control

QC8- Inspect parts - second check

Memo

0.00

0.00

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 74766

**\*74766\***

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October 6, 2011 9:16:51 AM

Item ID: D2940-1 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: U/R Stop **\*NS2\***  
 Item Name: Support  
 Start Date: 10/06/11 Start Qty: 20.00 **\*20\*** Cust Item ID:  
 Required Date: 11/15/11 Req'd Qty: 20.00 **\*20\*** Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
<b>*130*</b>									
HandFXtube	Memo	0.00							
Hand Finishing Crosstubes	Per note 8 on page 1 of dwg D2940, Prep inner concave surface of support and apply 3M Scotch-Weld as per dwg. 24h of cure time.								
140	QC3- Inspect Part Finish	0.00							
<b>*140*</b>									
QC	Memo	0.00							
Quality Control									
170	Identify as per dwg & Stock Location: <u>X-tube</u>	0.00							
<b>*170*</b>									
Packaging	Memo	0.00							
Packaging									

*Handwritten notes and stamps:*  
 11 11 09  
 11 - 11 - 10 (1)  
 11 - 11 - 10 (1)

W/O:		WORK ORDER CHANGES					
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**Work Order ID 74766****\*74766\***

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Item ID: D2940-1

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID: U/R

Item Name: Support

Stop **\*NS2\***

Start Date: 10/06/11 Start Qty: 20.00

**\*20\***

Cust Item ID:

Required Date: 11/15/11 Req'd Qty: 20.00

**\*20\***

Customer:

Reference:

Approvals:

Process Plan: \_\_\_\_\_

Date: \_\_\_\_\_

Tooling: \_\_\_\_\_

Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Stop **\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

180

QC21- Final Inspection - Work Order Release

0.00

**\*180\***

QC

Memo

0.00

Quality Control

21/11/14  
11-11-11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

# Picklist Print

October 6, 2011 9:16:55 AM

Page 1

Work Order ID: 74766

**\*74766\***

Parent Item: D2940-1

**\*D2940-1\***

Parent Item Name: Support

Start Date: 10/06/11

Required Date: 11/15/11

Start Qty: 20.00

Required Qty: 20.00

## Comments:

IPP C 02.11.26 Reformat; Added P/OKJ  
 IPP Rev:D Added priming as per Rev B 07-04-30 JLM  
 IPP E 08.03.19 Re-format Ec verified by DD  
 IPP Rev:F 08-10-22 add qc14 DD verified by:EC  
 11.08.04 as per dwg rev.C DD verf:EC  
 IPP Rev:G

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
DSK081		Manufactured	No			110	Each	14.0000	0.5	10.52632			
<b>*DSK081*</b>									<b>**</b>				
D2940-1 TURNING DETAIL													

*2A 11/11/14*

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT	4	
69717	4	
MAT050	10	
<i>72867</i>	10	

*10*

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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DART AEROSPACE LTD		Work Order: 77766
Description: Ø3.250 Support		Part Number: D2940-1
Inspection Dwg: D2940	Rev: B	Page 1 of 1

### FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
HAAS Section								
AA	0.240	0.260		.250				
AB	0.490	0.510		.500				
AC	0.140	0.160		.155				
AD	3.510	3.530		3.522				
AE	1.633	1.673		1.660				
AF	1.493	1.513		1.503				
AG	0.040	0.060		.050				
AH	0.188	0.193		.189				
AI	0.140	0.160		.150				
AJ	2.518	2.538		2.528				
AK	0.040	0.060		.050				
AL	0.010	0.020		.010				
AM	0.140	0.160		.153				
AN	0.350	0.450		.400				
AO	0.240	0.260		.250				
AP	0.150	0.170		.160				
AQ	0.053	0.073		.06				
AR	101.64	105.64		✓				
AS	0.260	0.267		.260				
AT	0.053	0.073		.063				
AU	4.118	4.138		4.130				
AV								
AW								
Accept/Reject								

Measured by: BL / SA Date: 11/12/09

Audited by: [Signature] Date: 11/11/09

Prototype Approval: Date:

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	
B	07.05.08	Dwg Rev. updated	KJ/JLM	
C	07.07.18	Dimension AS revised	KJ/JLM	
D	08.04.22	Reformat	KJ/JLM	[Signature]

W/O:		WORK ORDER CHANGES						
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W/O:		WORK ORDER CHANGES					
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